

Date: Thursday, 9/6/2007 8:50:55 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHUT-OFF VALVE ASSEMBLY
Job Number	: 34441		
Estimate Number	: 12186		
P.O. Number	: <i>N/A</i>	Part Number	: D3469041
This Issue	: 9/6/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3469 REV A1
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 28538	Drawing Revision	: A1
		Material	: <i>N/A</i>
Written By	: <i>JA</i>	Due Date	: 9/13/2007
Checked & Approved By	: <i>JA 07.09.06</i>	Qty:	1 Um: Each
Comment	: Est Rev: A New Issue 06-02-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D3469043	TUBE ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3469-043	Tube Assembly	<i>B28556</i>

mf

2.0	D3470041	SHUT-OFF VALVE SHAFT
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3470-041	Shut-Off Valve Assembly	<i>B 34436</i>

mf

3.0	D34705	PLATE VALVE
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D3470-5	Plate Valve	<i>B26116</i>

mf

4.0	D34707	valve seal
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3470-7	Valve Seal	<i>B 34412</i>

mf 07-09-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/6/2007 8:50:55 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE ASSEMBLY

Job Number: 34441

Part Number: D3469041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34709

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: B26387

mf

6.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN310-4 Nut M105057

mf

7.0

AN9604L

washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960-4L Washer M101389

mf

8.0

AN960416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN960-416 Washer M105519

mf

9.0

MS24665153

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

COTTER PIN

Batch: M19096

mf

10.0

MS35206217

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS35206-217 Screw M19402

mf 07-09-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 02/09/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/6/2007 8:50:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE ASSEMBLY

Job Number: 34441

Part Number: D3469041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

NAS679A04

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 NAS679-A04 Nut M102948

MF 07-09-13

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3469

MF 07-09-13 (1)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure Unit Opens and Closes Smoothly

En 06/04/13

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: _____

7/9/13 SP (1)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Donor 1/14

Job Completion



u 07-09-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

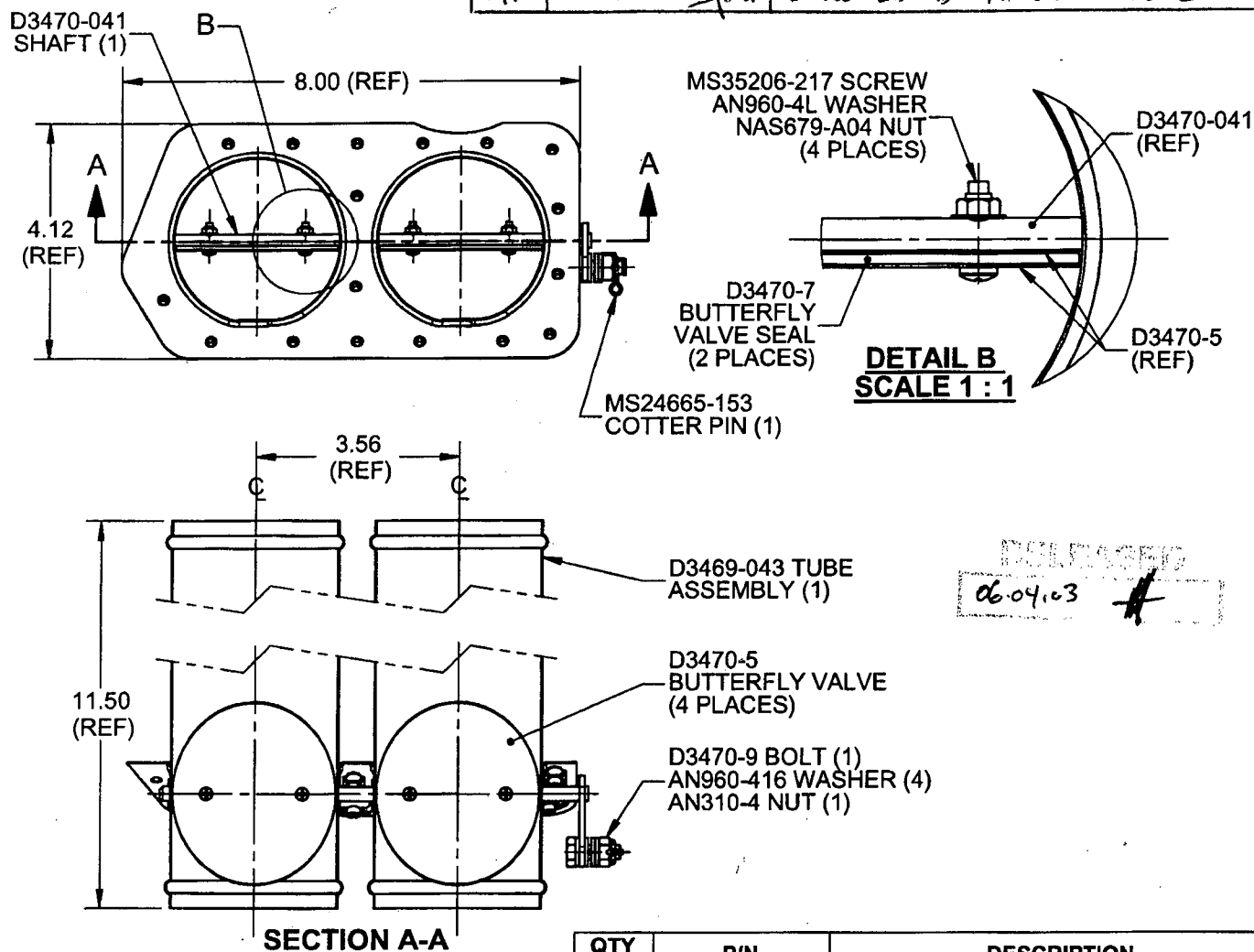
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3469	REV. A SHEET 1 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:3
A	05.12.12	NEW ISSUE	
A1	06.04.20	CORRECTED B.O.M. ON PAGE 2	



RELEASED
06.04.03 *[Signature]*

D3469-041 SHUT-OFF VALVE ASS'Y

NOTES:

- 1) IDENTIFY WITH DART P/N D3469-041 USING FINE POINT PERMANENT INK MARKER
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3469-041	SHUT-OFF VALVE ASSEMBLY
1	D3469-043	TUBE ASSEMBLY
1	D3470-041	SHUT-OFF VALVE SHAFT
4	D3470-5	BUTTERFLY VALVE
2	D3470-7	BUTTERFLY VALVE SEAL
1	D3470-9	BOLT
		SHOP COPY
		RETURN TO
1	AN310-4	NUT
		ENGINEERING
4	AN960-4L	WASHER
		UNCONTROLLED COPY
4	AN960-416	WASHER
		SUBJECT TO AMENDMENT
1	MS24665-153	COTTER PIN
		WITHOUT NOTICE
4	MS35206-217	SCREW
		WORK ORDER
4	NAS679-A04	NUT
		NO <i>34441</i>

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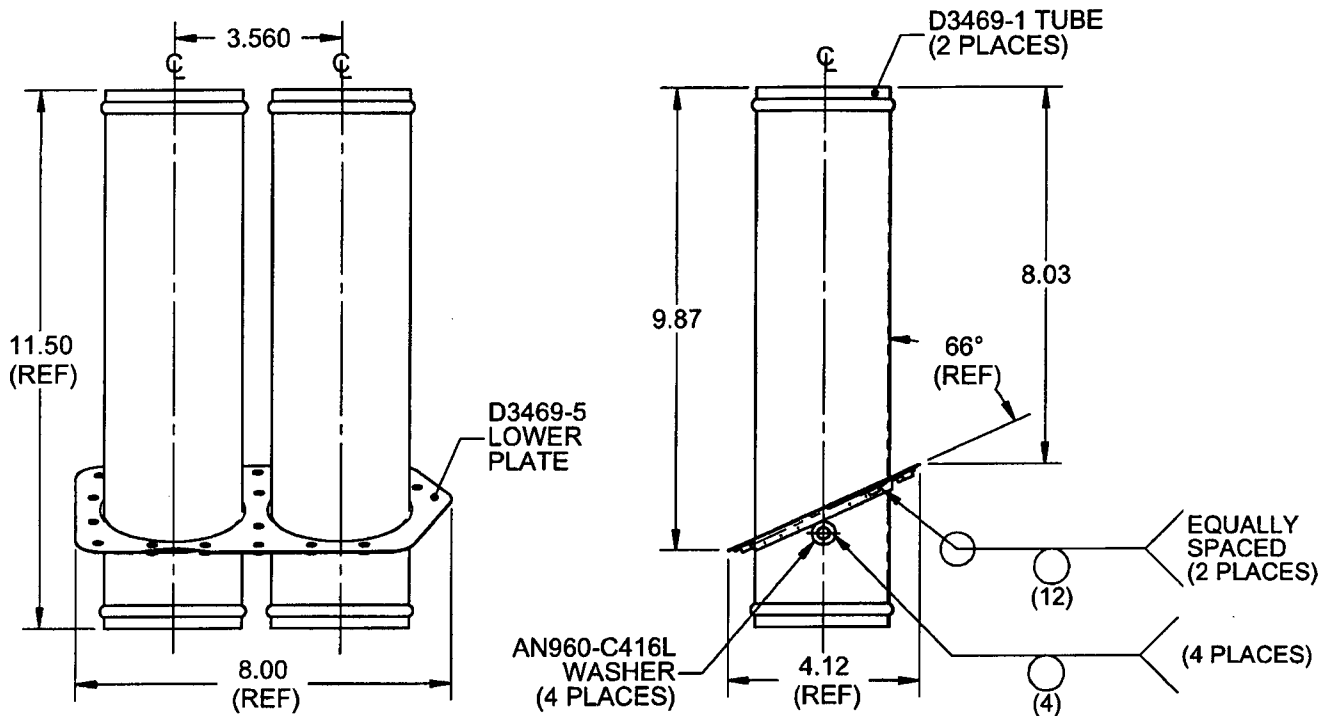
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3469	REV. A SHEET 2 OF 5
DATE 05.12.12	TITLE SHUT-OFF VALVE ASS'Y		SCALE 1:4

RELEASED

06.04.03

**D3469-043 TUBE ASSEMBLY****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

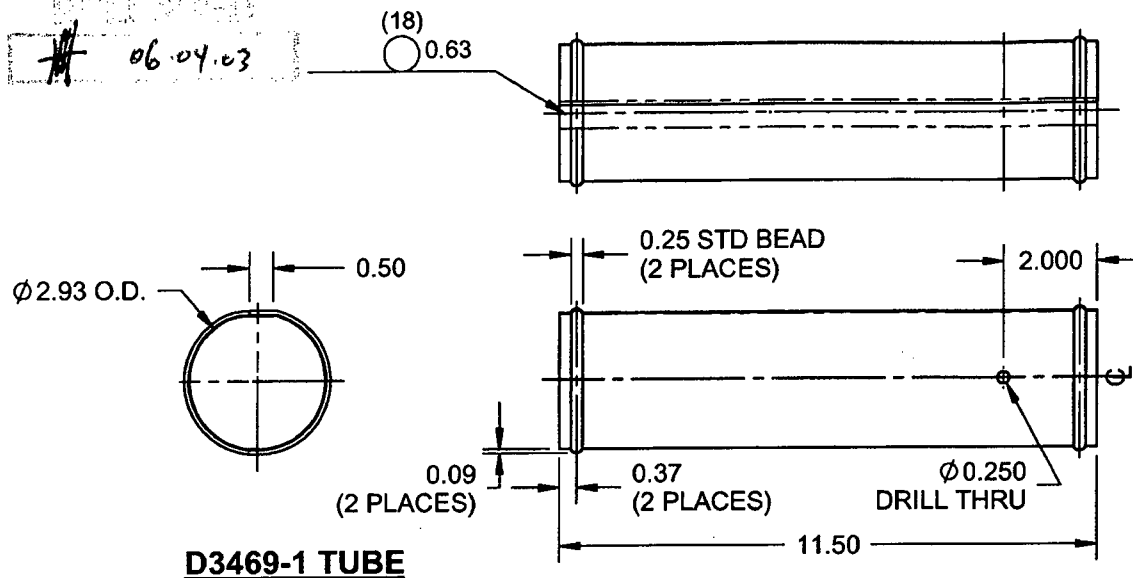
QTY -043	P/N	DESCRIPTION	SHOP COPY
X	D3469-043	TUBE ASSEMBLY	RETURN TO ENGINEERING
2	D3469-1	TUBE	UNCONTROLLED COPY
1	D3469-5	LOWER PLATE	SUBJECT TO AMENDMENT
4	D3470-5	PLATE VALVE	WITHOUT NOTICE
4	AN960-C416L	WASHER	WORK ORDER NO. 34441

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3469	REV. A SHEET 3 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4

**D3469-1F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

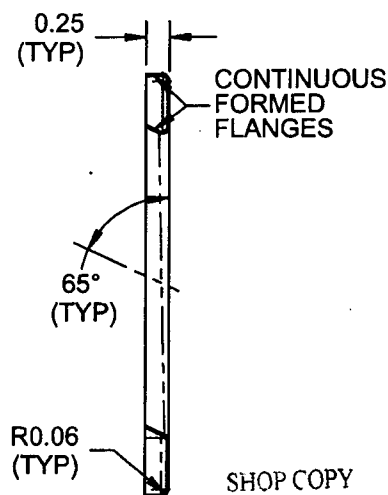
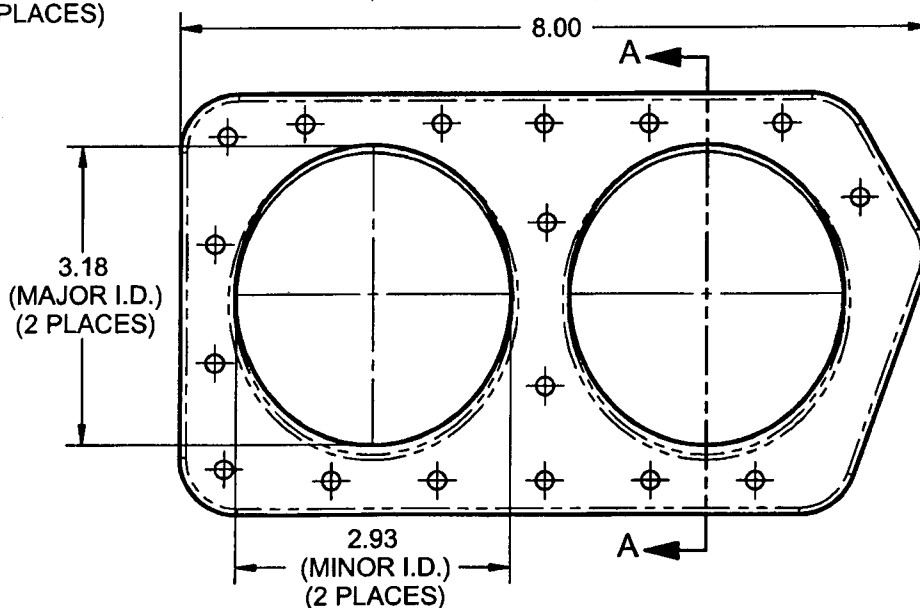
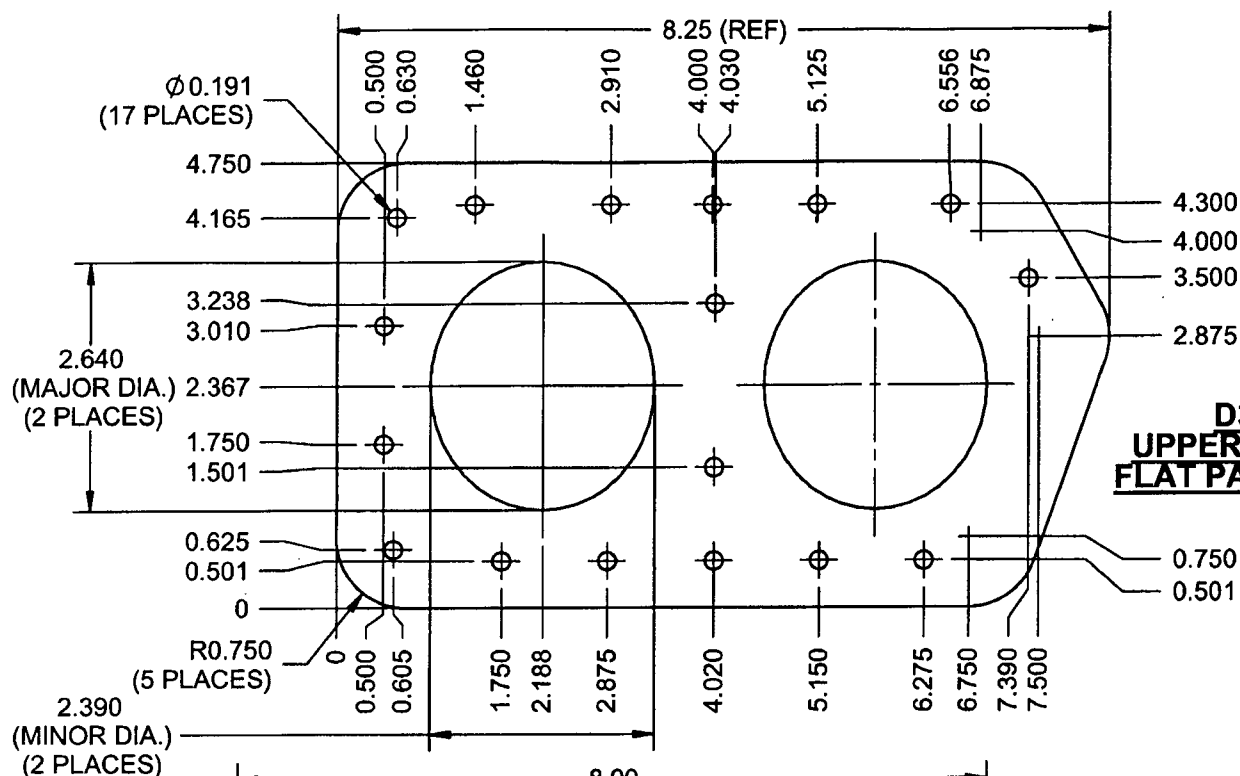
WORK ORDER
NO. *[Signature]*

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CHECKED <i>B</i>	APPROVED <i>B</i>	DRAWING NO. D3469	REV. A SHEET 4 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:2



D3469-3 UPPER PLATE BENDING DETAIL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: NONE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
SECTION A-A ENGINEERING
INCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *3444*

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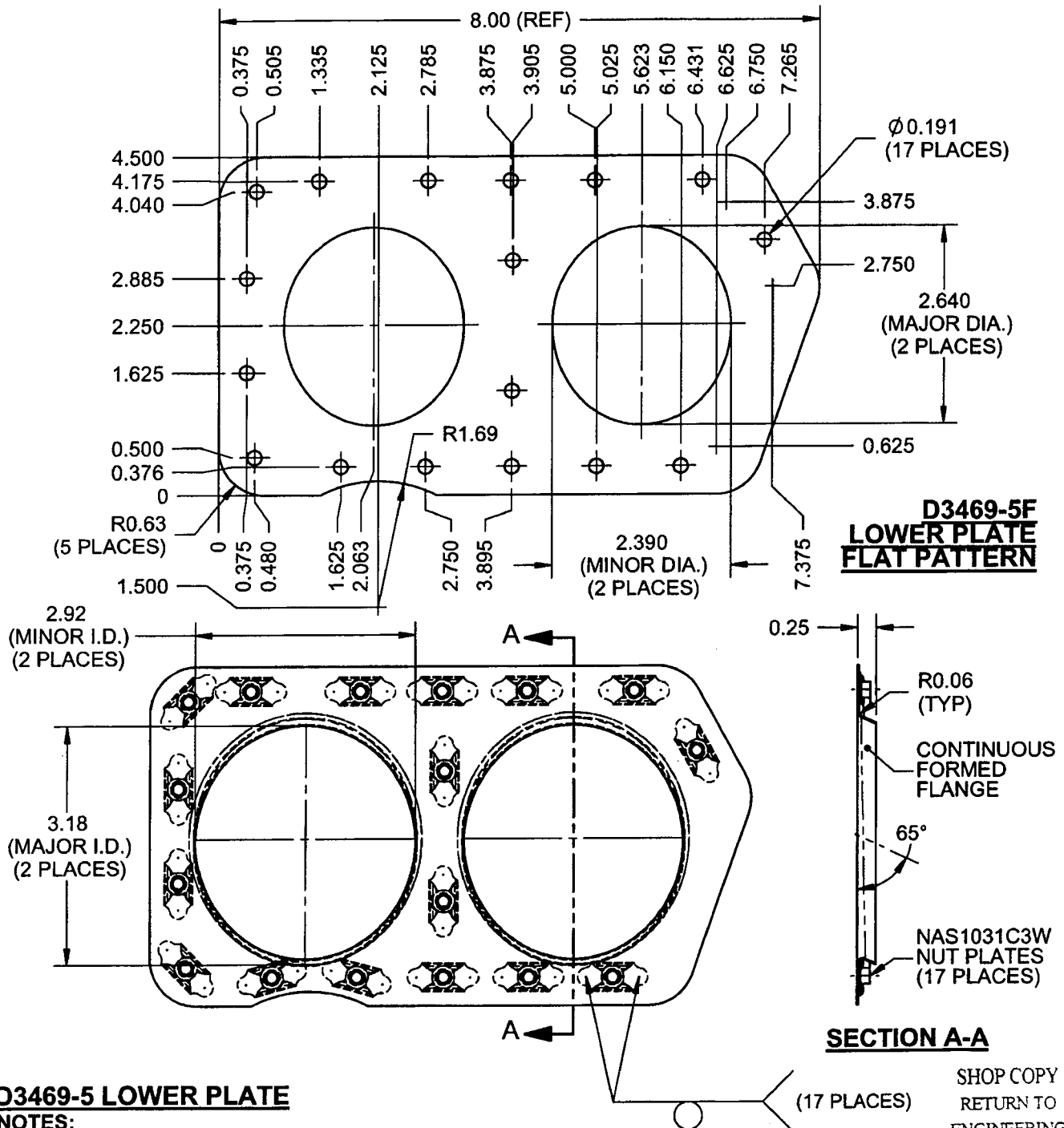
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3469	REV. A SHEET 5 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:2

**D3469-5 LOWER PLATE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD NUT PLATES PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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